Dart Aerospace Ltd. Wednesday, 24/09/2008 6:59:47 AM Date: Linda Lacelle User: **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : SADDLE SPACER Customer Job Number : 42262 **Estimate Number** : 11063 : D2935 **Part Number** P.O. Number S.O. No. : : D2935 REV B : 24/09/2008 **Drawing Number** This Issue : N/A Prsht Rev. : NC Project Number : // : SMALL /MED FAB : B First Issue Type **Drawing Revision** : 40282 Material **Previous Run** Each 20 Um: : 26/09/2008 Qty: **Due Date** Written By Checked & Approved By : Est A 00.06.06 Comment New Issue EC Est Rev:B Now 6061-T6 06-06-23 JLM **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: M6061T6S080 6061-T6 .080 Sheet 1.0 Comment: Qty.: 1.0647 sf(s) 0.0532 sf(s)/Unit Total: Material: M6061-T6 0.080" Thick Batch 107460 B89-24 FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2935 Dwg Rev: 18 2-9-34 Dwg Rev:\_ Prog Rev:\_ 2-Deburr if necessary 3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE 1B 8-9-24 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC8 SECOND CHECK wester Comment: SECOND CHECK HAND FINISHING RESOURCE #1 HAND FINISHING1 5.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1

| Dart Ae   | rospace | Ltd        |        |                    |              |           |       |                                     |                          |
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| W/O:      |         |            |        | WORK ORDER         | CHANGES      | ,         | ,_,_, |                                     |                          |
| DATE STEP |         |            | PRO    | OCEDURE CHANGE     | В            | y Date    | Qty   | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
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| R:     | WORK ORDER NON-CONFORMANCE (NCR)                     |                        |  |  |  |  |  |  |
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|        | ion of NC Corrective Action Section B Verification A | Approval Approval      |  |  |  |  |  |  |
| ATE ST |  | Chief Eng QC Inspector |  |  |  |  |  |  |
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NOTE: Date & initial all entries

▶ Wednesday, 24/09/2008 6:59:47 AM Date: User: Linda Lacelle **Process Sheet** Drawing Name: SADDLE SPACER Customer: CU-DAR001 Dart Helicopters Services Part Number: D2935 Job Number: 42262 Job Number: Description: Seq. #: Machine Or Operation: INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 PACKAGING 1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion W 08.09.25

Page

Form: rprocess

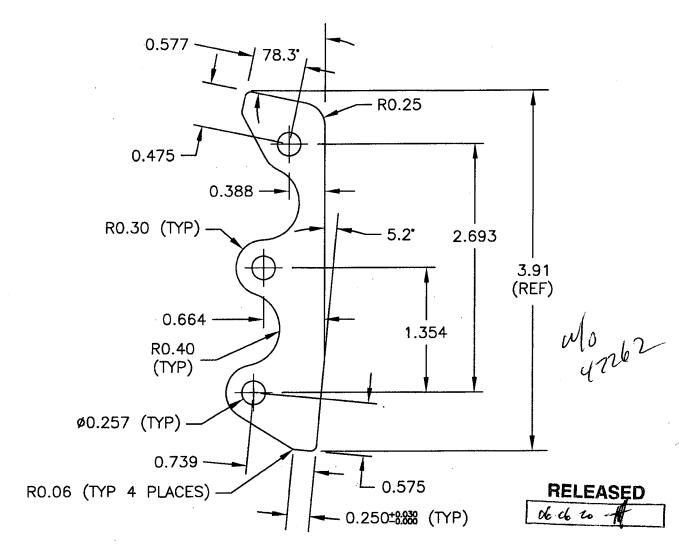
| W/O: |      | WORK ORDER CHANGES |                 |          |      |          |                                     |                         |
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| DATE | STEP | PR                 | OCEDURE CHANGE  | Ву       | Date | Qty      | Approval<br>Chief Eng /<br>Prod Mgr | Approva<br>QC Inspector |
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| NCR: |      |                             | WORK ORDER NON-CONFORMANCE (NCR) |                              |                |                           |           |                          |  |  |  |
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|      |      | Description of NC           | Corrective Action Section B      |                              |                |                           | Approval  | A                        |  |  |  |
| DATE | STEP | Description of NC Section A | Initial<br>Chief Eng             | Action Description Chief Eng | Sign &<br>Date | Verification<br>Section C | Chief Eng | Approval<br>QC Inspector |  |  |  |
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NOTE: Date & initial all entries



| <br>DESIG | . <del>Т</del> | #        | DRAWN BY  | DART AEROSPACE I     |              |
|-----------|----------------|----------|-----------|----------------------|--------------|
| CHEC      |                | <u> </u> | APPROVED  | DRAWING NO.          | REV. B       |
|           | F              | H        | THE SHAPE | D2935                | SHEET 1 OF 1 |
| DATE      |                |          |           | TITLE                | SCALE        |
| <br>06.0  | 05.29          | )        |           | SADDLE SPACER        | 1:1          |
| Α         |                |          | 99.11.02  | NEW ISSUE            |              |
| В         |                |          | 06.05.29  | ADD 6061-T6 MATERIAL |              |



## NOTES:

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)

OR

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)

- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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| DART AEROSPA      | ACE LTD  |        | Work Order:       | 42262 |              |             |
|-------------------|----------|--------|-------------------|-------|--------------|-------------|
| *                 | ,        | ***    |                   |       |              |             |
| Description:      | SADDLE   | SPACED | ·A <sub>3</sub> , | 7.4   | Part Number: | D 2935      |
| Inspection Dwg: N | nazt Rev | . 0    |                   |       |              | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

|   |               | · | *         |
|---|---------------|---|-----------|
| X | First Article | X | Prototype |

| Drawing<br>Dimension | Tolerance     | Actual Dimension | Accept     | Rejest | Method of<br>Inspection | Comments |
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|--------------|--------|-------------|----------|---------------------|-----|---------|
| Measured by: | PB     | Audited by: | 5, ,     | Prototype Approval: | 1)/ |         |
| Date:        | 8-9-74 | Date:       | 68/09/24 | Date:               | 19  |         |
|              |        |             |          | •                   |     |         |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| Α   |      | New Issue | KJ/JLM     |          |